

Garant
Solid carbide milling cutter HPC, ZOx, Ø f8 DC: 4mm

Order data

Order number	202251 4
GTIN	4045197538550
Item class	11X

Description
Version:

Sturdy roughing end mill **without** knuckle profile.

With strong core, **special chip breaker recesses** and **large polished flutes**.

Application:

For roughing milling with high demands on the component surface.

Note:

NEW GENERATION AVAILABLE!

Recommended successor product is No. 202017.

Technical description

Cutting edge Ø D _c	4 mm
Overhang length L ₁ incl. recess	24 mm
Shank form	HA
No. of teeth Z	3
Feed f _z for slot milling in short-chipping aluminium	0.035 mm
Corner chamfer width at 45°	0.1 mm
Feed f _z for side milling in short-chipping aluminium	0.045 mm
Recess Ø D ₁	3.7 mm
Shank Ø D _s	6 mm
Overall length L	80 mm
Flute length L _c	6.5 mm

Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Tolerance nominal \varnothing	f8
Balance quality with shank	G 2.5 with HA
Helix angle	45 degrees
Corner chamfer angle	45 degrees
Coating	ZOX
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	0.3×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	suitable only under restricted conditions	250 m/min	N
Aluminium (short chipping)	suitable	240 m/min	N
Alu > 10% Si	suitable	120 m/min	N
CuZn	suitable	120 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		

dry	suitable only under restricted conditions
Air Services	suitable only under restricted conditions
Shank grinding Type HB	129100 HB